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D2842-042
Job Sheet 167719



Part No: D2842-042

Job Qty: 4 ea

Part Name: Step Assembly RH, 206 Float



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/6/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea		12/5/17	0.00	0.00	Start Up Large Fab2		D.M.L 17-11-27
100	Large Fab	4 pcs		12/5/17	0.00	5.75	Large Fab 8		D.M.L 17-11-27
105	QC	4 pcs		12/5/17	0.00	0.00	QC6		17-11-28
110	Large Fab	4 pcs		12/5/17	0.00	5.75	Large Fab 2		
120	QC	4 pcs		12/5/17	0.00	0.00	QC9		PD 17-12-04
130	QC	4 pcs		12/5/17	0.00	0.00	QC5		PD 17-12-04
140	HandFinish	4 pcs		12/5/17	0.00	1.65	HandFinish1		2017-12-05 JSC
150	QC	4 pcs		12/5/17	0.00	0.00	QC7		
160	Large Fab	4 pcs		12/5/17	0.00	5.75	Large Fab 2		SL 17/12/6
170	QC	4 pcs		12/5/17	0.00	0.00	QC10		
180	QC	4 pcs		12/5/17	0.00	0.00	QC5		
185	HandFinish	4 pcs		12/5/17	0.00	1.65	HandFinish2		BEB 17/12/11
190	Powdercoat	4 pcs		12/5/17	0.00	0.70	Powdercoat1		BR 17-12-12
200	QC	4 pcs		12/5/17	0.00	0.00	QC3		BEB 17/12/13
210	HandFinish	4 pcs		12/6/17	0.00	1.65	HandFinish3		BEB 17/12/16
220	QC	4 pcs		12/6/17	0.00	0.00	QC5		
230	Packaging	4 pcs		12/6/17	0.00	0.00	Packaging3		Smis
240	QC21-SA	4 Ea		12/6/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

Descriptions: ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding

110 - 1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842 2- OPEN HOLES TO SIZE AS PER DWG (0.250") 3-Grind end cap weld flush

160 - 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.

185 - ***Touch up step with alodine per qsi 005 prior to powder coat***

190 - START TIME: 3:05 O.V.T: 3:20 FINISH: 4:05 M138467

210 - 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch:

Sika Flex M138654 wing walk M138373

Job Allocations

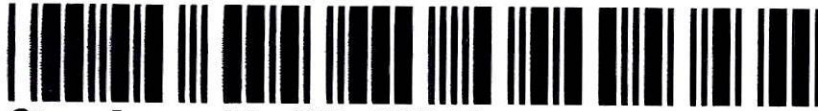
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2622-120C	4	14	0	0
	D2734 - 5008231	8	14	0	0
	D3459-15011655	8	14	0	0
	NAS1149C0332R	12	3,888	0	0
210-HandFinish	D3459-3-5008750	8	10	0	0
	MS27039C1-07 FM132317-10	12	86	0	0
	NAS1329C3KB130 5023251	12	27	0	0

Specifications could not be found.			
Part Specifications			
NAS1515H3L			
FM137361-25			
12			
NAS1149CO 3322 - FM138408-1			
222			
0			
0			

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Step Assembly RH, 206 Float

PART NO: D2842-042

Revision:

Operation: Large Fab

Change No:

Mfg Date: 11/24/17

Job No: 167719